

31

Date: Wednesday, 7/11/2007 3:05:40 PM
 User: Kin. Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SHORT STEP ASSEMBLY HIGH SKID LH
 Job Number : 33508
 Estimate Number : 10575
 P.O. Number : N/A Part Number : D350591213
 This Issue : 7/11/2007 S.O. No. : N/A Drawing Number : D3078 REV A
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LARGE FAB ASSY Drawing Revision : A
 Previous Run : 31615 Material : N/A
 Due Date : 7/30/2007 Qty: 10 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev:B 05.10.14 Modified step 10 KJ/EC
 Est Rev:C 06-06-19 Added D2732-030 AS PER DSI9294
 JLM
 Est Rev:C 06-06-27 Revised as per DSI9340 JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-591-213 CHG002

Per Attached

2.0

D2622120C

Extrusion



Comment: Qty.: 0.5000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1XB30199

1 D2622-120C

Extrusion

532858

a.m

07.07.27

10

3.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622-120 extrusion to 59.75" long as per Dwg D3078

a.m 07.07.27

10

2-Drill extrusion as per Dwg D3078 using Jig DT8680 for rivets.

a.m 07.07.27

10

3-Deburr

a.m 07.07.27

10

4.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

50 07/07/27 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Date: Wednesday, 7/11/2007 3:05:40 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP ASSEMBLY HIGH SKID LH

Job Number: 33508

Part Number: D350591213

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D30671

End Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3067-1

End Plate 3.32836

PH 07-07-27 10

6.0

D30631

Support



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3063-1

Support 3.30892

PH 07-07-27 10

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8681, weld Fwd End Plate as per QSI 004 & Dwg D3072

A/R Aluminum Rod M103794

M104721

3-Grind End Plate flush

A.M. 07.07.31

PH 07-07-27 10

PH 07-07-30 10

10

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/07/31 10

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/07/31 10

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

A.M. 07.07.31

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Drawing Name: SHORT STEP ASSEMBLY HIGH SKID LH

Job Number: 33508

Part Number: D350591213

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



M 070731



10

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

12.0

D3065041

Step Leg Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3065-041

Step Leg Assy

B3339

Q.M 07.07.31

10

13.0

D30661

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3066-1

Spacer

B33100

Q.M 07.07.31

10

14.0

MS20600AD4W4

Rivets



Comment: Qty.: 16.0000 Each(s)/Unit Total : 160.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 MS20600AD4W4

Rivet

M104715

Q.M 07.07.31

10

15.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Rivet Leg Assembly as per Dwg D3078.

Q.M 07.07.31

10

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Q.M 07.08.08 (10)

17.0

D30671

End Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3067-1

End Plate

B32836

Q.M 07.08.08

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP ASSEMBLY HIGH SKID LH

Job Number: 33508

Part Number: D350591213

Job Number:



Seq. #:

Machine Or Operation:

Description:

18.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel Aft end for welding

2-Inspect for foreign object as per QSI 024

3-Weld Aft End Plate as per QSI 004 & Dwg D3078
A/R Aluminum Rod *M103794*

4-Grind End Plate flush

Q.10

07.08.09

10

PE. 07.08.08 10

PE. 07.08.08 10

PE. 07.08.08 10

19.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/08/09 (10)

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/08/09 (10) LH

21.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Touch Up Chemical conversion

M. A

07/08/13

10X

22.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 105068

BL/M. A 07.08.13

(10)

23.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3078 and QSI 005 4.4

M 104942

FL 07/08/14 (10)

24.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION.



Comment: Inspect Powder Coat and Wing Walk

FL 07/08/15 (10) LH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP ASSEMBLY HIGH SKID LH

Job Number: 33508

Part Number: D350591213

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

26.0

D22301

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2230-1 Clamp B32163-

27.0

D22303

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2230-3 Clamp B30993-

28.0

D2732

Rubber Extrusion



Comment: Qty.: 1.0500 f(s)/Unit Total : 10.5000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2732-030(3" LONG) Rubber Cushion B26472-

29.0

D2856400

Abrasion Strip



Comment: Qty.: 0.6000 f(s)/Unit Total : 6.0000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2856-400(7.2") Abrasion Strip B32992-

30.0

AN335A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN3-35A Bolt M104021-

B07/08/15 @

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP ASSEMBLY HIGH SKID LH

Job Number: 33508

Part Number: D350591213

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

AN411A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 AN4-11A

Bolt

M102280-

32.0

AN413A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Bolt

Batch: M104746-

33.0

AN960JD10

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD10

Washer

M104885-

34.0

AN960JD416

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN960JD416

Washer

M104215-

35.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21042L3

Nut (or -3)

M104547 (5x)

M104936 (5x)

36.0

MS21042L4

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 MS21042L4

Nut (or -4)

M102552-

CP07/08/150

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP ASSEMBLY HIGH SKID LH

Job Number: 33508

Part Number: D350591213

Job Number:



Seq. #:

Machine Or Operation:

Description :

37.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

en 07/08/15 (x10 kits)

38.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591-213

Location: _____

PPP Rev: _____

07/08/15 (10) SP

39.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07-08-15

Job Completion



07/08/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
02.09.20

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>CP</i>	DRAWING NO. D3078	REV. A SHEET 1 OF 2
DATE 02.09.11		TITLE STEP ASSEMBLY, HI SHORT SCALE NTS	
A	02.09.11	NEW ISSUE	

Part No.	Description	QTY -041	QTY -042
D3078-041	Step Assembly, High Short (LH)	X	
D3078-042	Step Assembly, High Short (RH)		X
D2622-60	STEP EXTRUSION	1	1
D3063-1	SUPPORT	1	1
D3065-041	LEG ASSEMBLY	1	1
D3066-1	SPACER	2	2
D3067-1	END PLATE	2	2
MS20600AD4W4	RIVET	16	16

GENERAL NOTES:

- 1) -041 SHOWN, FOR -042 INSTALL D3063-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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WITHOUT NOTICE
WORK ORDER
NO. 33508

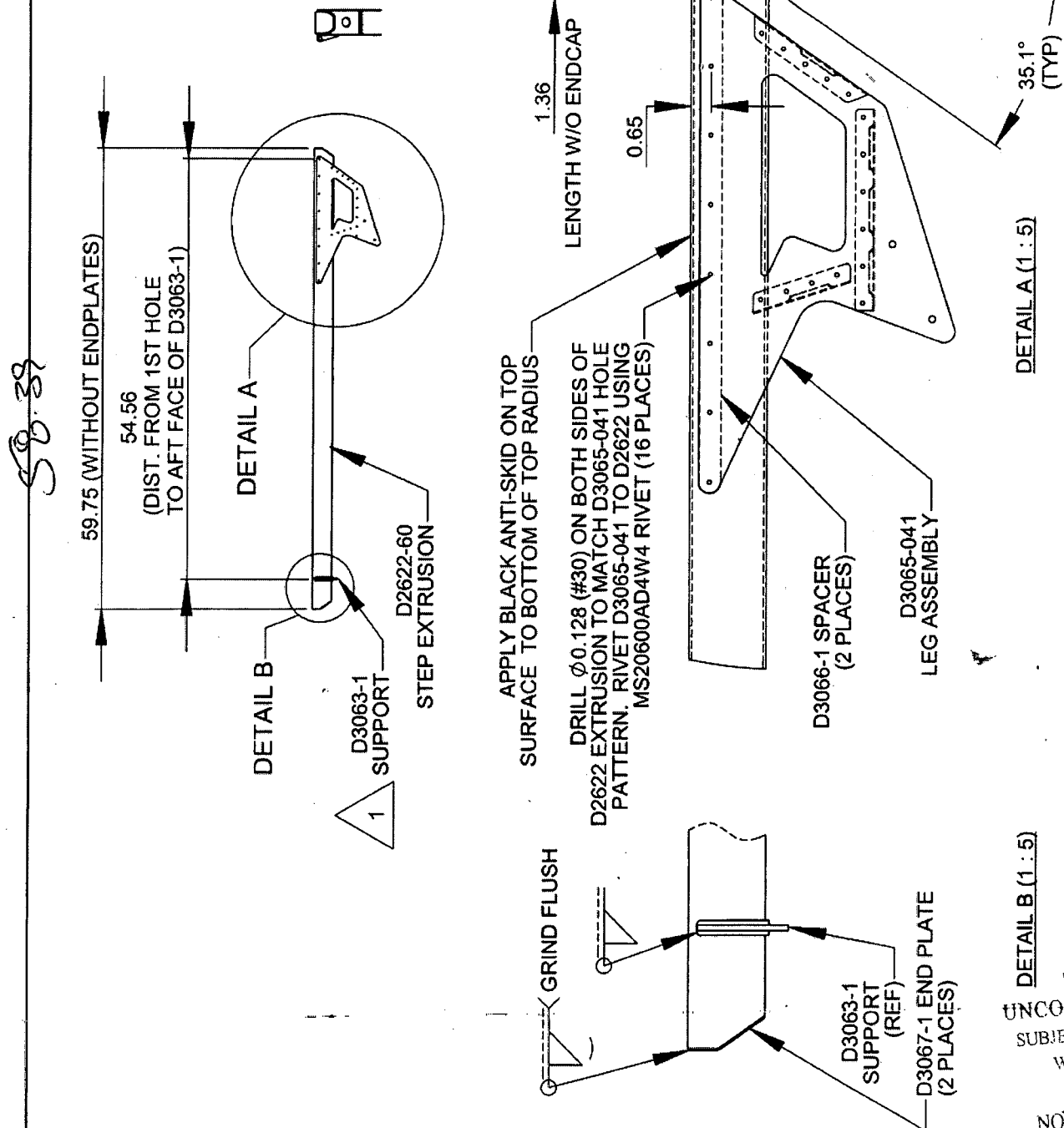
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DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3078	REV. A SHEET 2 OF 2
DATE 02.09.11		TITLE STEP ASSEMBLY, HI SHORT	SCALE 1:20

RELEASED
02.09.2011



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Job Number	: 33508		
Estimate Number	: 10575		
P.O. Number	:	Part Number	: D350591213
This Issue	: 7/11/2007 S.O. No. :	Drawing Number	: D3078 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type : LARGE FAB ASSY	Drawing Revision	: A
Previous Run	: 31615	Material	:
Written By	:	Due Date	: 7/30/2007 Qty: 10 Um: Each
Checked & Approved By	:		
Comment	Est Rev:B 05.10.14 Modified step 10 KJ/EC Est Rev:C 06-06-19 Added D2732-030 AS PER DSI9294 JLM Est Rev:C 06-06-27 Revised as per DSI9340 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-591-213 CHG002

07.07.23

2.0	D2622120C	Extrusion
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Comment: Qty.: 0.5000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2622-120C	Extrusion	

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622-120 extrusion to 59.75" long as per Dwg D3078

2-Drill extrusion as per Dwg D3078 using Jig DT8680 for rivets.

3-Deburr

REFERENCE ONLY

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP